

Work Order ID 60151

Monday, June 28, 2010 9:14:15 AM



Page 1

Item ID: D2512

Revision ID:

Item Name: Basket Lid 205/350

Start Date: 6/28/2010 Start Qty: 1.00

Required Date: 7/9/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	Rev E

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 111679 0.00
Large Fab 0.00

Memo

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

SAD 10-07-05

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo

0.00

10.07.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60151

Page 2

Monday, June 28, 2010 9:14:15 AM

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 6/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8/10/08

⑦

Memo

0.00

130



Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per OSI005 4.3-Alum

0.00

M 114841

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 1:10

OVEN TEMPERATURE: 400°

FINISH TIME: 1:40

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

① BL 10-7-8.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Item ID:	D2512	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid 205/350					
Start Date:	6/28/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	7/9/2010	Req'd Qty:	1.00	Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish	HandFinishing	0.00							
	Memo	0.00							
Hand Finishing	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch								
150  QC	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
Quality Control									
160  Packaging	Identify as per dwg & Stock Location:	0.00							
	Memo	0.00							
Packaging									

M112594 M114332
Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch M114432

7M, 10/07/13 (1X)

GA 660147 SB 10/07/13

10-7-12

D

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Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid 205/350

Start Date: 6/28/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 7/9/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ME
10-7-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, June 28, 2010 9:14:19 AM

Page 1 / 3

Work Order ID: 60151



Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF
 IPP Rev:N 06.04.05 Added level21
 EC IPP REV:N ADDED D3490-
 1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	32.0000	2	2			
Clevis													

Location	Loc Qty	Loc Code
WA	32	
52498	2	
55729	30	

~~355791~~ → (2)

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

D2232-1		Manufactured	No			100	Each	32.0000	2	2			
Basket Hinge													

Location	Loc Qty	Loc Code
WA	32	
55791	32	

(2)

D2327-1		Manufactured	No			100	Each	21.0000	2	2			
Spacer Bushing													

Location	Loc Qty	Loc Code
WA	21	
52832	1	
54658	20	

(2)

Dart Aerospace Ltd

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Page 2

13

Work Order ID: 60151

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

J D2506

Manufactured No

100

Each

5.0000

1

1



Label Plate



Pl 10.07.005

Location

Loc Qty

Loc Code

WA

5

57836

2

59263

3

Manufactured No

100

Each

27.0000

2

①
2

Pl 10.07.05

Location

Loc Qty

Loc Code

ST

1

59121

1

WA

26

46086

2

51745

2

57185

1

59265

21

Manufactured No

100

Each

9.2838

1

① *

①

SAD 10-07-05

D3166-3

Manufactured No

100

Each

9.2838

1



Basket Hoop



Location

Loc Qty

Loc Code

WA

9.283751053

55697

2.1053E-05

57504

3.28373

59266

6

1.000

Monday, June 28, 2010 9:14:19 AM

Shop Packet Print

P

Not Enough

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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13

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

1,035.184

18

18.94737



Expanded Metal Flat SS



SAD

10-07-05

Location

Loc Qty

Loc Code

MAT

1035.184133

114399

37.542

114594

6.9382

114744

15.201843

114809

329.3811

114853

146.12099

115012

500

18.9473

M304TS0.750W.065

Purchased

No

100

f

630.8996

43.5804

45.87411



304 SQ Tube .75x.75x.065W



SAD

10-07-05

Location

Loc Qty

Loc Code

MAT

1.4628

112398

0

114482

1.4628

WA

629.436835

114520

629.436835

45.8741

Monday, June 28, 2010 9:14:19 AM

Shop Packet Print

Page 3

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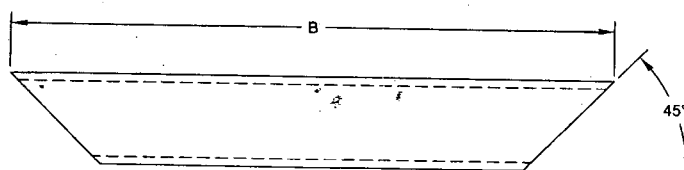
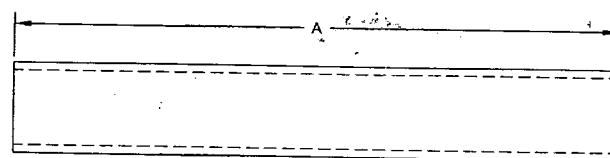
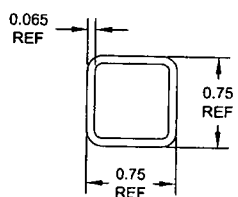
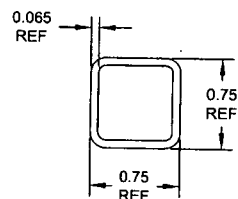
NOTE: Date & initial all entries

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2		25.50	RIB
D2512-3	2		95.30	RIB
D2512-5	6	30.84		RIB
D2512-7	3	30.63		RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60151
PS10621

RELEASED
08-08-21



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	W	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

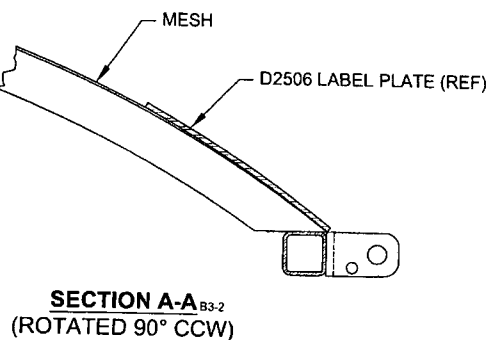
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY

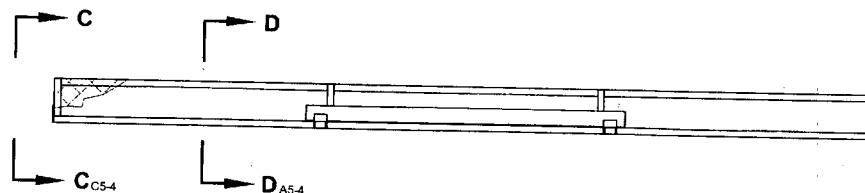
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE




D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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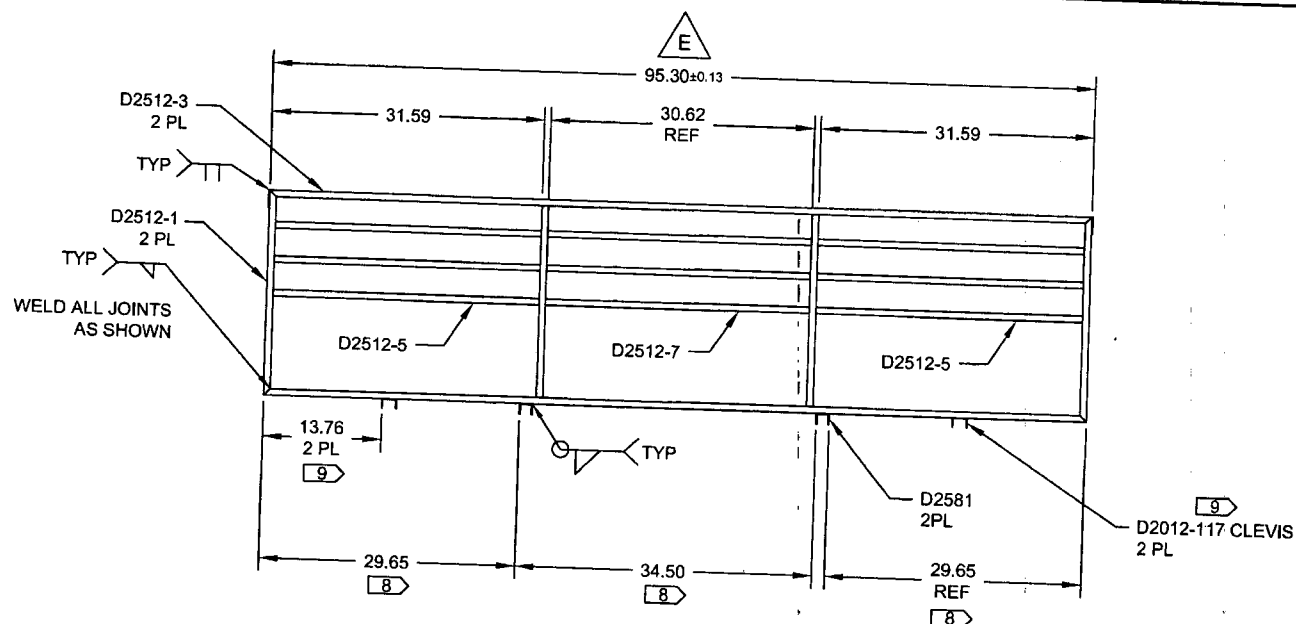
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

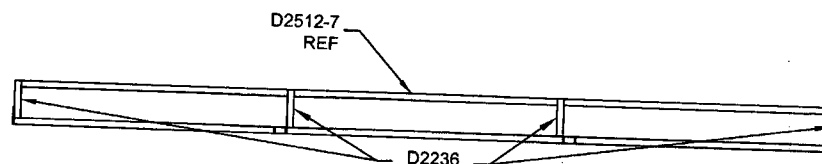
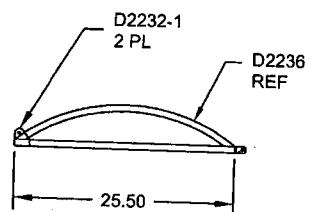
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J		
MFG. APPR.	D		
APPROVED	AP		
DE APPR.	AP		
DATE	08.06.17	DRAWING NO. D2512	REV. E SHEET 3 OF 4
		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
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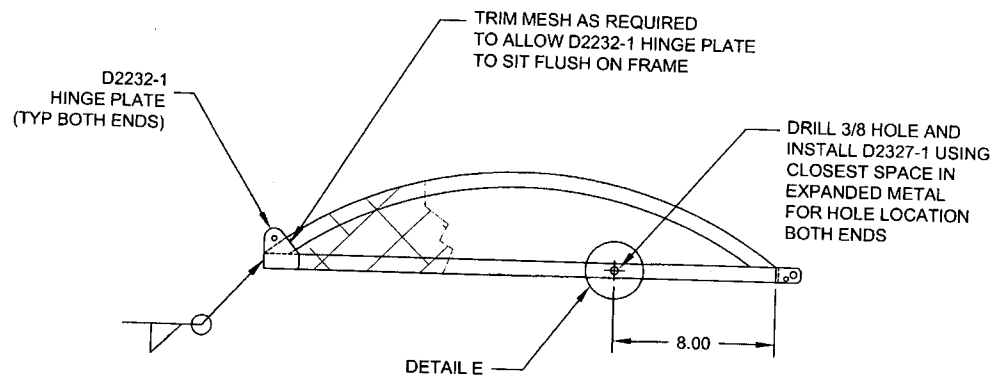
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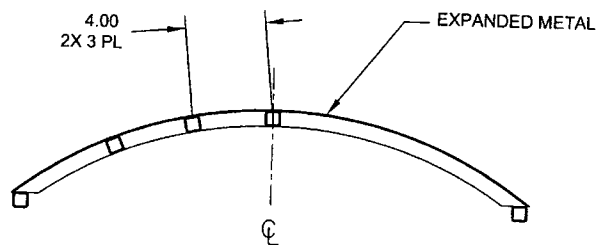
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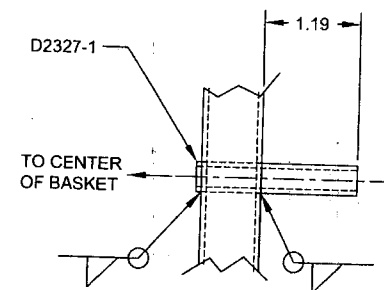
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED
08.06.17

W/O 60131

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO.
MFG. APPR.		D2512
APPROVED		TITLE
DE APPR.		BASKET LID ASSEMBLY (350/212)
DATE	08.06.17	SCALE
		NTS

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8 7 6 5 4 3 2 1

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